

Work Order ID 56188

February 12, 2010 10:03:43 AM

shp 19/02



Item ID: D3006-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 2/12/10

Start Qty: 1.00

Req'd Qty: 1.00

2



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3006

Rev A

100

0.00



SHEAR

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3006

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B 10-2-16

4

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-2-16

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Page 2

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Required Date: 2/19/10 Req'd Qty: 1.00

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

8.0602/17

QC

Memo

0.00

(H)

Quality Control

140

Large Fab

0.00

Large Fab

Memo

0.00

Weld 7560 hardcoat & D3009 cup-as per dwg D3005 & QSI 004

A/R S.S. Rod Batch: M9326

A/R Hard facing Rod Batch: M113078

EL

10-2-18

(X9)

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

ST

D

BE 2/2/18

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Start Date: 2/12/10 Start Qty: 1.00

Required Date: 2/19/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8.10/02/18

(X4)

170



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QS1005 4.3

M105642

0.00

0.00

Memo

START TIME: 11:30AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 12:00PM

=> M 10/02/18

(X4) /

P107

180



Packaging

Packaging

Identify as per dwg & Stock Location

263

0.00

0.00

Memo

10-2-18

(X4)

50

W/O: 56188		WORK ORDER CHANGES						
DATE	STEP	Perm. change	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/18	#175		ADD step for QC 3 P/c inspection.	A	10-02-18			S 10/02/18
			QC 3 →	PA	10-02-18	④.		S 10/02/18

Part No: D3006-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56188

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Item ID: D3006-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 2/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/18 *[Signature]*
MF
10-2-18

Picklist Print

February 12, 2010 10:03:42 AM

Page 1

Work Order ID: 56188



Parent Item: D3006-041



Parent Item Name: Wearplate

Start Date: 2/12/10

Required Date: 2/19/10

Comments: IPP A 01.04.04 New Issue EC IPP RevB: now made on waterjet DD
10.02.12 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

96.1138

1.0965

S,



1010/1025 sheet 16GA

AB 10-2-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT 105706

96.1138

111410

96.1138

105706

D3009-1

Manufactured

No

140

Each

157.0000

8.0000



Cup

④

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

157

20432

17

36482

87

37488

53

-17
-15

EL

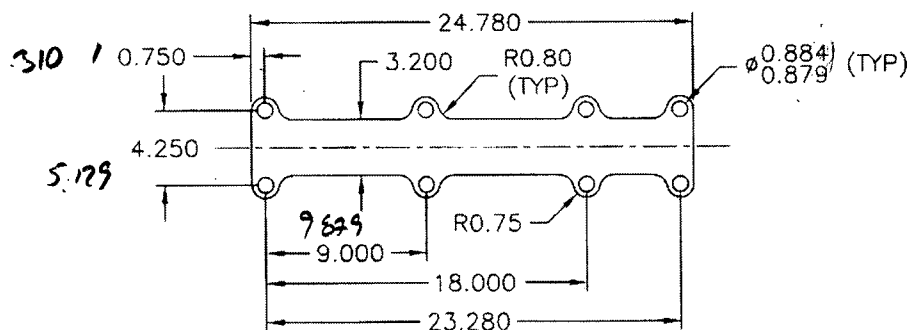
10-2-17



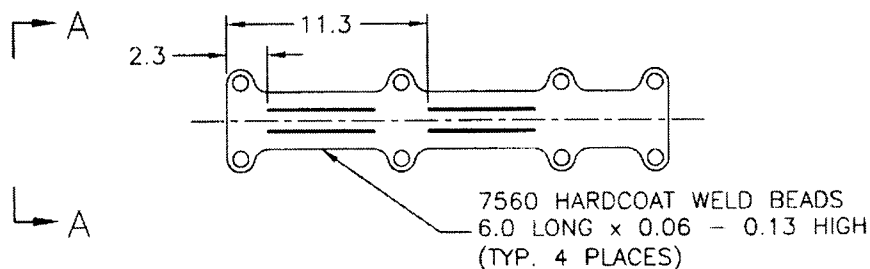
DESIGN KF	DRAWN BY LF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3006	REV. A SHEET 1 OF 1
DATE 01.03.23		TITLE WEARPLATE	SCALE 1:10
A	01.03.23	NEW ISSUE	

RELEASED
19 04 04

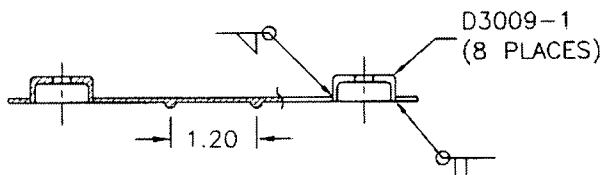
D3006-1 FLAT PATTERN



D3006-041 WELDMENT



7560 HARDCOAT WELD BEADS
6.0 LONG x 0.06 - 0.13 HIGH
(TYP. 4 PLACES)



SECTION A-A
(ROTATED 90° CCW, SCALE 2:5)

BREAK ALL SHARP EDGES 0.010 TO 0.020

WELD PER QSI 004

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 SERIES STEEL 16
GAUGE (0.060 THICK)

FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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